

Jim

Work Order ID 91491

October-10-12 4:02:16 PM

91491

Page 1

Item ID: D4544-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Center

Start Date: 10/10/2012 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/01/2013 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-10-11 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4544

B

115

0.00

115

Small Fab

Memo

0.00

Small Fab

FORM AS PER DWG USE DT9832
flat lenght 46.00"

15 ϕ FF 13-01-03

117

QC5- Inspect part completeness to step on W/O

0.00

117

QC

Memo

0.00

Quality Control

DAS 15 2-89 13-1-3

15

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

15 2-89 13-1-4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>					Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Page 2

Item ID: D4544-1

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Center

Start Date: 10/10/2012 Start Qty: 15.00

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Cust Item ID:

Required Date: 10/01/2013 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC7-Inspect Chemical Conversion Coat

0.00

130

QC

Memo

0.00

Swb
13.1.7

15

Quality Control

140

Identify as per dwg & Stock Location: *S 157* 0.00

140

Packaging

Memo

0.00

15x

SP
13-01-07

Packaging

150

QC21- Final Inspection - Work Order Release 0.00

150

QC

Memo

0.00

13/1/10

MP
13-01-07

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Picklist Print

October-10-12 4:02:20 PM

Page 1

Work Order ID: 91491

Parent Item: D4544-1

Parent Item Name: Retainer, Center

91491

D4544-1

Start Date: 10/10/2012

Required Date: 10/01/2013

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP revA 12.01.17 new issue EC verified by:DD
REV:B 12.02.24 as per dwg reva DD verf:EC IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4544-3		Manufactured	No				f	5,868.000		57.495			

D4544-3
Extrusion

**

FF 13-01-03

Location

Loc Qty

Loc Code

MAT07

5868

86171

5868

57.495

NCR: Yes / No

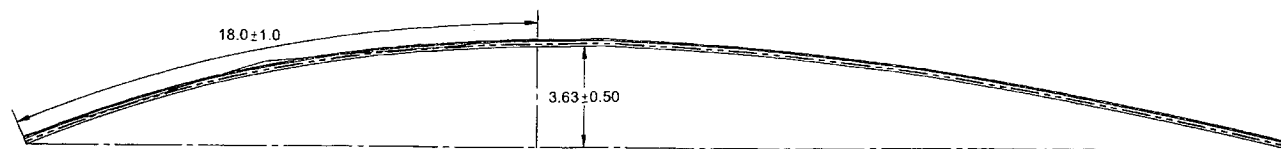
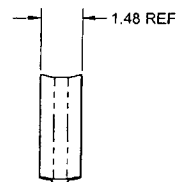
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

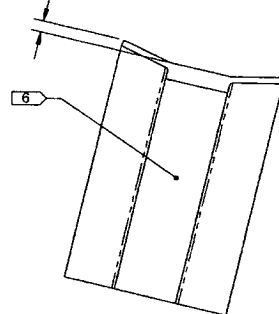
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D4544-1 RETAINER, CENTER

FORM TO 0.10 TYP
(D4544-1F ONLY)



VIEW A-A
SCALE 4X
CROPPED VIEW

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 91491 MCT
12-10-11

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: MAKE FROM D4544-1F OR D4544-3-460
FLAT LENGTH = 46.00"
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4544-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.61 lbs

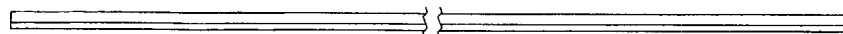
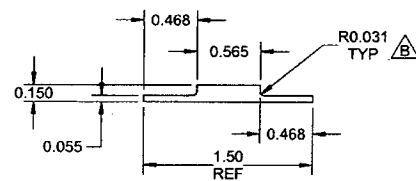
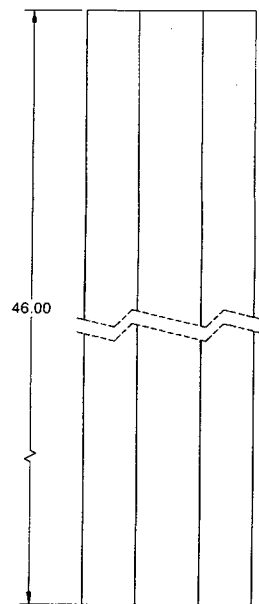
B	ADD -1F (WAS -1); ADD -3, -1 NOW BENT AND FORMED. R0.031 WAS R0.015 (B6-2)	CP	12.04.20
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4544
REV. B
SHEET 1 OF 3
SCALE
NTS

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

91491



D4544-1F RETAINER, CENTER

RELEASED
2012-05-03
WJ

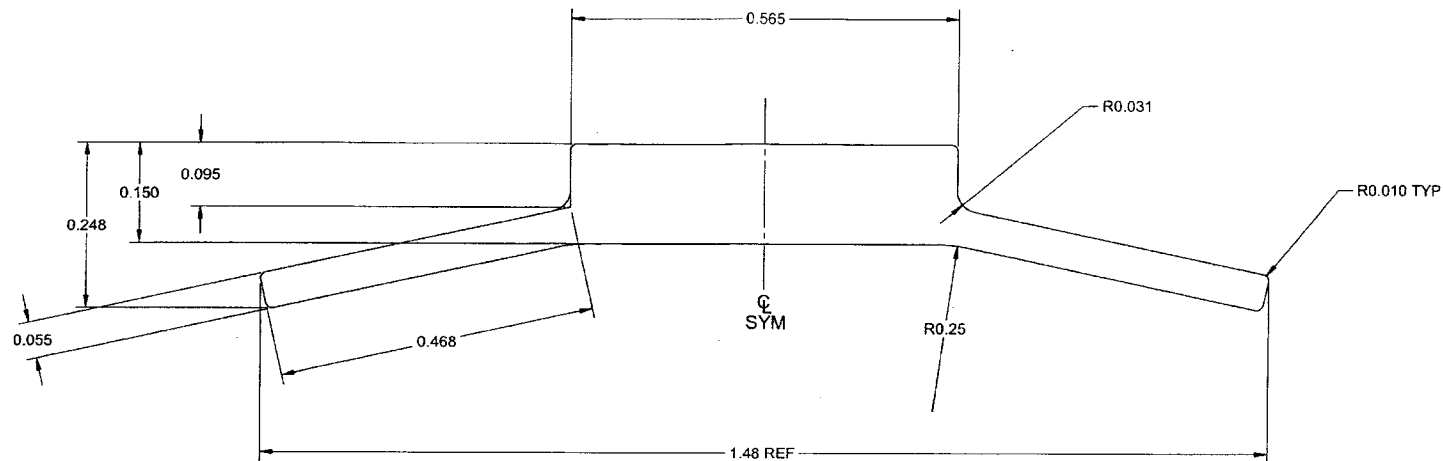
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET OR BAR
 QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR QQ-A-250/11 OR AMS-QQ-A-250/11 (OR AMS 4025/4027)
 OR ASTM B211 OR ASTM B221 OR ASTM B209
 REF DART SPEC. M6061T6S OR M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.61 lbs

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D4544	REV. B
MFG. APPR.		SHEET 2 OF 3	
APPROVED	WJ	TITLE	SCALE
DE APPR.		RETAINER, CENTER	NTS
DATE	12.04.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SPECIFICATION CONTROL DRAWING

91491



D4544-3-XXX EXTRUSION

2012-05-07
2012-05-07

NOTES:

1) D4544-3-XXX EXTRUSION

LENGTH
WHERE 'XXX' IS LENGTH IN TENTHS OF AN INCH
EG. 46" LONG EXTRUSION = D4544-3-460

- 2) MATERIAL: 6061-T6 ALUMINUM EXTRUSION PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.0137 lb/in
- 8) NO TOOLING ID MARKS

DESIGN	<i>g</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>SS</i>	D4544	SHEET 3 OF 3
APPROVED	<i>SS</i>	TITLE	SCALE
DE APPR.	<i>SS</i>	RETAINER, CENTER	NTS
DATE	12.04.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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